

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015709**Date Inspected:** 13-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao / Li yan hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 3G-050 located on PCMK SEG3004Y for Segment 12AW the welder is identified as 047864. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4213-Tc-U4b-2.

FCAW welding of weld joint 2G-246 located on PCMK SEG3004J for Segment 12AW the welder is identified as 201215. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint 2F-030 located on PCMK SP3103-001 for Segment 13AW the welder is identified as 044774. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

**OUTSIDE SHOP**

11CW

SMAW welding of weld joint 3F-037 located on PCMK CA86 for Segment 11CW the welder is identified as

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200113. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

11EE

SMAW welding of repair weld joint 3G-002 located on PCMK SSD19A-PP108 for Segment 11EE the welder is identified as 054013. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-3G (3F)-Repair and WR11254.

SMAW welding of repair weld joint 3G-009 located on PCMK SSD19-PP108 for Segment 11EE the welder is identified as 204339. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-3G (3F)-Repair and WR11253.

BAY#16

SAW welding of weld joint 1G-004 located on PCMK BP3074-001 for Segment 13AW the welder is identified as 045270. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

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BAY#19

This QA inspector performed UT of buttering location of base metal areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Bike path BK004A-011,010,008. The weld designations reviewed as follows.

BK004A-008-BKX9A, BKX10A, BKX8A.

BK004A-010-BKX9A, BKX10A, BKX8A

BK004A-011-BKX9A, BKX10A, BKX8A

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

No relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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